

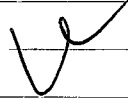
Work Order ID 89806

September-10-12 7:51:08 AM

89806

Page 1

Item ID: D3189-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Chafing Shield
 Start Date: 9/10/12 Start Qty: 47.00 ***47*** Cust Item ID:
 Required Date: 9/10/12 Req'd Qty: 47.00 ***47*** Customer:
 Reference: Scrap/Destroy - ECN12-643

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3189	C								

135

0.00

135

Crosstubes

Memo

0.00

Crosstubes

PULL FROM STOCK:
 26 X D3189-1 86652
 6 X D3189-1 89609
 11 X D3189-1 B85515
 4 X D3189-1 B36065
 SCRAP/DESTROYER ECN12643

AS 12-9-10

140

QC21- Final Inspection - Work Order Release

0.00

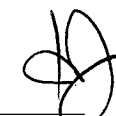
140

QC

Memo

0.00

Quality Control

12/9/11 

W 12.09.10

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

September-10-12 7:51:07 AM

Page 1

Work Order ID: 89806

Parent Item: D3189-1

Start Date: 9/10/12

Required Date: 9/10/12

Parent Item Name: Chafing Shield

Start Qty: 47.00

Required Qty: 47.00

Comments: IPP B05.08.22No longer made in-houseKJ/JLM
IPP Rev:C 06-03-24 Rolling Now made in House JLM
IPP Rev:D 07-04-16 As per Rev B JLM
waterjet DD verf:JLM
IPP Rev:E 11.05.11 now made on

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3189-1 Chafing Shield		Manufactured	No				Each	0.0000		47			

h

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
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FAULT CATEGORY												
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List Lots

Page 1 of 1

September-10-12 7:29:22 AM

Criteria : Item ID: d3189-1 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
D3189-1 Chafing Shield	Main Warehouse LG052	86652 ✓	8/29/12	26.0000	QC21		
	Main Warehouse LG052	89609 ✓	9/07/12	6.0000	QC21		
	Main Warehouse LG053	85515 ✓	8/29/12	11.0000	QC21		
	OFFSHORE FG	36065 ✓	8/29/12	4.0000	QC21		
Total:				47.0000			

89806 h

ENGINEERING CHANGE NOTICE **DART AEROSPACE LTD**

Date: 12.09.05	Job No.: ENG3107SEP	ADR Yes/No: N	ADR Date: <i>12.09.05</i>	ECN #: 12- 643
Product No.: D212-664		Created By: CP	Approved By: <i>AM</i>	
Product Name: Crosstube		Checked By: <i>AM</i>		

Distribution	Reqd	Resp	Initial / Date
Production Manager / Coord.	Y	LL/MF	
Purchasing Coord.	N		
Production Engineering Coord.	Y	DD	
Customer Technical Support	Y	MB/DS	
Customer Order Processing	N		

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord.	Y	PS	
QC Coordinator	Y	ED	
Customer Support	Y	SW/LM	
VP Marketing / BD	NY	AM	
Marketing	NY	HM	

Reason for Change:

Documents Affected:

Release: D3189 Rev. C D412-664-249-B-3 DSI 9629 Rev. A
 DSI 9629 Rev. A D412-664-245-D-3
 D412-664-243-E-4 D412-664-145-D-3

PAPERWORK UPDATE ☐

PARTS MUST COMPLY ☐

PREVIOUS PARTS SATISFACTORY ☒

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	NY	MB	SEE BELOW.	
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Master Document List (MDL)	Y	CP		
6	Update Product Compatability Matrix	N			
7	Create Eurocopter Form (FEE)	N			
8	Notify TC / FAA of Change	N			
9					

#	Document Control Actions	Reqd	Resp	Notes	Complete
10	Move Electronic Files/Design Journal	Y	KJ		12.09.06 <i>AM</i>
11	Update Product Specification Files	Y	KJ		12.09.06 <i>AM</i>
12	Update Approved/Preliminary Dwg PDF Files	Y	KJ		12.09.06 <i>AM</i>
13	Update Document Record (DR)	N			
14	Update Product Development Summary	N			
15	Update QSI 021 and/or STC Approval List	N			
16	Create/Update Parts / STC Database	N			
17	Update / Verify ARC Database	N			
18	Create / Update Change Record Form / Item Card Database	Y	KJ		12.09.06 <i>AM</i>
19	Create / Update PPP's	Y	KJ		
20	Red Decals required?	Y	KJ		
21	Update Document Control Database / Laminated Dwgs	N			
22	Update Grey Project / Electronic Binder PDF Files	Y	KJ		
23	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		
24					

Description / Action:

- D3189-1 & D3189-3 Chafing Shields updated to enlarge part, to facilitate installation
- DSI 9629 Rev. A created to inform customer how to replace new chafing shields
- DEO's created for crosstubes to show how new wearplates should be oriented on the crosstubes, also to reduce required torque on clamps
- CHG # UPDATED: D412-664-105 @ CHG 004, D412-664-203 @ CHG 009, D412-664-205 @ CHG 004, D412-664-209 @ CHG 004
D412-664-303 @ CHG 002
- Linda: DSI 9629 Rev. A needs to be sent to customer who bought the (3) D412-664-203 tubes with new chafing shield
- Existing crosstubes kits are OK to ship. Existing D3189-1/-3 chafing shields should be scrapped.
- When sending out replacement D3189-1/-3 Chafing Shields, the customer will need a copy of DSI 9629 Rev. A. Need some way to flag this in intuitive.
- PROVIDE SOAG PARTS w/ COPY OF DSI 9629.A

ECN Verified & Complete: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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QA Closed: _____ Date: _____

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